The invention may be further understood by reference to the following comparative examples.

EXAMPLE 1

Cleanroom wiper style "A" having edge constructions substantially as illustrated and described in relation to FIGS 1 and 2 with double layer folded edges in the machine direction and discontinuous fused edges in the cross machine direction was formed from tightly constructed balanced knit fabric of double knit construction made up of 70 denier 36 filament polyester yarn with 41 wales per inch X 40 courses per inch and a weight of 3.7 ounces per square yard. Segments of both the double layer folded edges in the machine direction and the discontinuous edges in the cross-machine direction in thirty-one of the wipers were tested for particle generation under application of tension according to the testing procedure as described above. The results of such testing are set forth in Table 1.

EXAMPLE 2

A cleanroom wiper style "B" formed of fabric as described in Example 1 was formed having thermally sealed edges in both the machine direction and the cross-machine direction. Thermal sealing was carried out in accordance with the teachings of U.S. Patent 5,069,735. Edge segments in the machine direction and in the cross-machine direction in thirty-one of the wipers were tested for particle generation under tension according to the

testing procedure as described above. The results of such testing are set forth in Table 1.

EXAMPLE 3

A cleanroom wiper style "C" having inwardly extending fused edges as described in U.S patent 4,888,229 to Paley et al. in both the machine direction and the cross-machine direction was obtained from a commercial source. The fabric forming the wiper was made up of 70 denier 34 filament polyester yarn in a double knit construction with 37 wales per inch X 47 courses per inch with a weight of 4.2 ounces per square yard. Edge segments in the machine direction and in the cross-machine direction in thirty-one of the wipers were tested for particle generation under application of tension according to the testing procedure as described above. The results of such testing are set forth in Table 1.

EXAMPLE 4

A cleanroom wiper style "D" was formed having thermally sealed edges in both the machine direction and in the cross-machine direction. Thermal sealing was carried out in accordance with the teachings of U.S. Patent 5,069,735. The fabric forming the wiper was a double knit construction of 70 denier 36 filament polyester yarns having 43 wales per inch X 37 courses per inch and a weight of 3.52 ounces per square yard. Edge segments in the machine direction and in the cross-machine direction in

thirty-one of the wipers were tested for particle generation under application of tension according to the testing procedure as described above. The results of such testing are set forth in Table 1.

Table 1

Wiper Style	A Machine Direction	A Cross-Machine Direction	B Machine Direction	B Cross-Machine Direction	C Machine Direction	C Cross-Machine Direction	D Machine Direction	D Cross-Machine Direction
Average Particle Count Measurement	409	1357	3702	1433	2875	3731	2030	1598
High Particle Count Measurement	936	2205	5955	2754	6018	7173	3712	2601
Low Particle Count Measurement	84	203	1471	402	1020	1643	879	682
Standard Deviation	233	604	1455	556	1251	1634	721	614
Statistical Mean Lower Confidence limit (99%)	301	1078	3029	1176	2296	2975	1697	1314
Statistical Mean Upper Confidence limit (99%)	516	1636	4375	1690	3454	4487	2363	1882

This data is believed to confirm that the double edge construction of wiper style "A" results in a dramatic improvement in both the average and actual number of particles generated in tension over that which is believed to have been available heretofore. Likewise, in regions where a non-folded extended border zone is utilized, the inwardly extending discontinuous fused border edge construction of wiper style "A" provides much lower particle generation than the inwardly extending solid fused border of wiper style "C".

While the present invention has been illustrated and described in relation to certain potentially preferred embodiments, constructions, and procedures, it is to be understood and appreciated that such embodiments,